

Skip Sept-5

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:13:44 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Job Number : 28153
 Estimate Number : 10824
 P.O. Number : N/A Part Number : D412630032
 This Issue : 15/08/2006 S.O. No. : N/A Drawing Number : D412-630 REV.J, P17
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : J
 Previous Run : 27782 Material : N/A Due Date : 06/09/2006 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

KS 06-08-30

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

SB 06/09/13

3.0 D3463042 Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	B28176

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	① B28069 ② B27784

5.0 D3443041 Strut Weldment Assembly




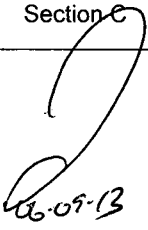
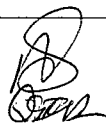
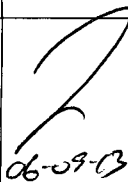
Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
			① 28068 ② B27783

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/13	2	removed 3 MS24665- 227 + 3 MS24665-302		pieces were scrap + replace	SB 06/09/13			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description:

1 D3443-041 Strut ass'y

6.0

D34439

PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3443-9	Pin

Batch

② B27780 ④ B28166

7.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN4CH3	BOLT
A/R	MS20995c25e	Lockwire

Batch

M19390
M101537

8.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4C14	BOLT

Batch

M19096

9.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-7	Bushing

Batch

② B27782 ④ B28170

10.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN310-4	Nut

Batch

① B19096 ② B19356

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	M19094 M102073

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	② B27798 ④ B28171

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	B25536

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	M19096

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M16941

SB 06/29/13 ③

15.1 QCS Inspect: Assy

Job 09-13 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

17.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Pick:

Qty	Part Number	Description
1	D3454-1	Bushing

Batch

B28167 34

Handwritten notes and signatures:
17.0000 11/12/06
17.0000 11/12/06
17.0000 11/12/06

18.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:

Qty	Part Number	Description
2	D3454-3	Bushing

Batch

B24168 64

19.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:

Qty	Part Number	Description
2	D3454-5	Bushing

Batch

B28169 64

20.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)
Pick:

Qty	Part Number	Description
6	D3455-1	Spacer

Batch

B28171 18X

21.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:

Qty	Part Number	Description
2	D3455-3	Spacer

Batch

B28172 B27789 64

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

22.0	D3462042	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3462-042	Bracket ass'y

Batch

B2779/ 1X ✓
B28174 2X ✓

23.0	AN3104	NUT
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN310-4	Nut

Batch

M19096 6X

24.0	AN3105	NUT
------	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN310-5	Nut

Batch

M19096 6X ✓

25.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick:

Qty	Part Number	Description
3	AN3-C5A	Bolt

Batch

M101692 9X ✓

26.0	AN44C12	eyebolt
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN44-C12	Eyebolt

Batch

M19649 3X ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

27.0	AN4C15	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	M19213 3x ✓

28.0	AN5C11	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	M19096 3x ✓

29.0	AN5C15	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	M19096 3x ✓ M19213

30.0	AN960C10	WASHER
------	----------	--------



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 35.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	M10106421x ✓

31.0	AN960C516	WASHER
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	M19697 3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

32.0	MS210433	Nut
------	----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS21043-3	Nut	M100218 9x ✓

33.0	MS24665227	COTTER PIN
------	------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	M100218 3x ✓ M19096 4x M102073x2

34.0	MS24665229	COTTER PIN
------	------------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	M19096 6x

35.0	NAS1515H5	Washer
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H5	Washer	M101067 3x 06/07/12 (3)

36.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

37.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Test fit on aircraft in Eng. lab.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:13:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28153

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CL06/09/13

(3)

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev: Draft

CL06/09/13

(3)

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

CL06/09/13

(3)

Job Completion



h 06/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

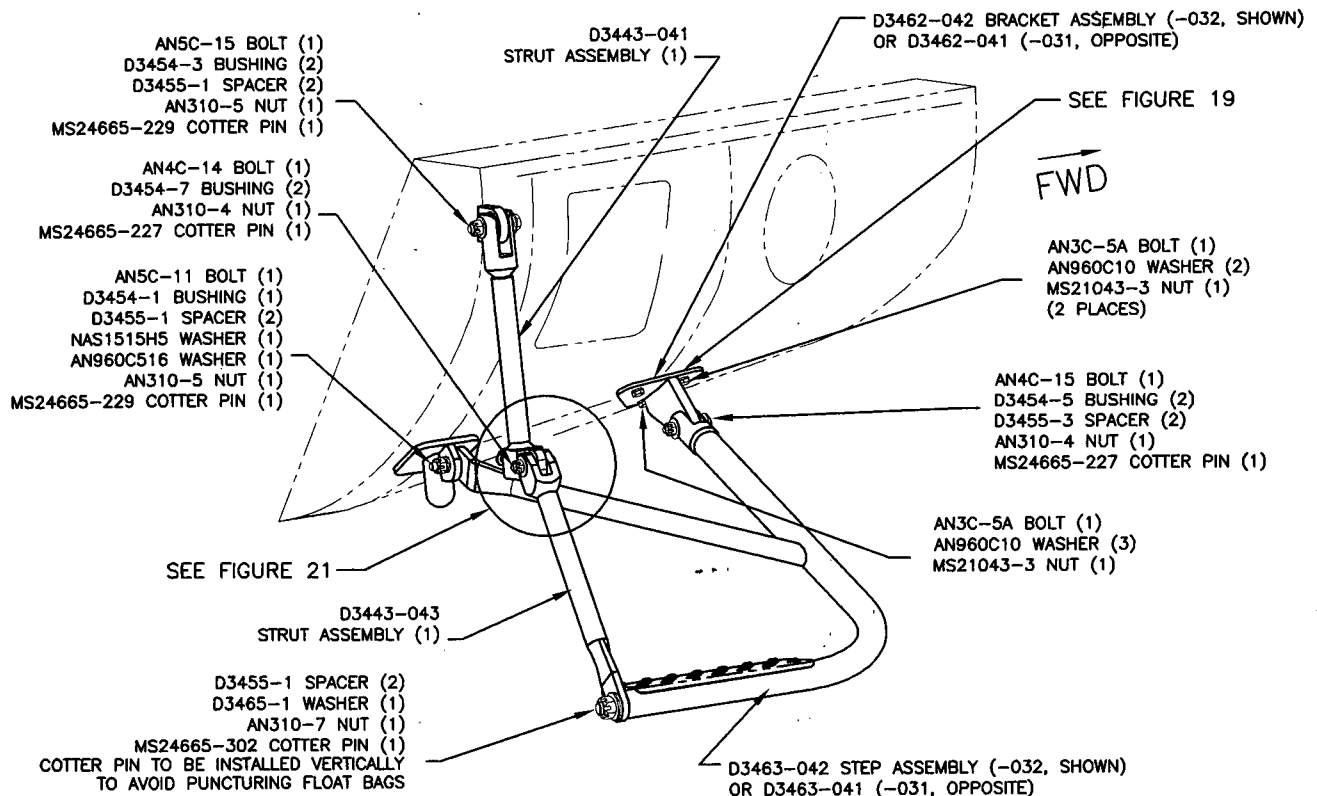
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

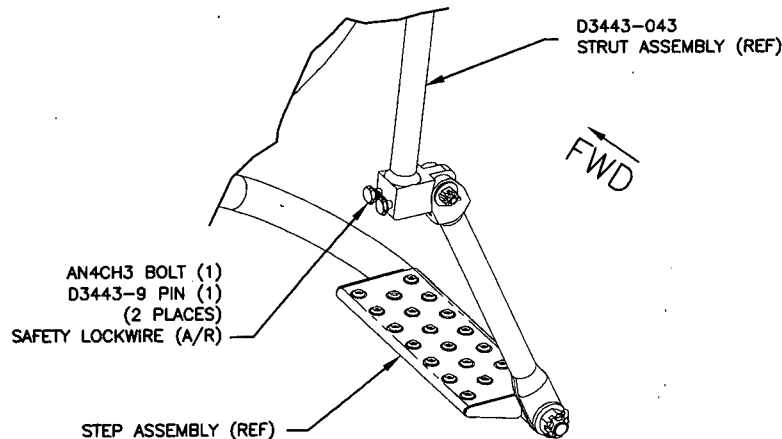
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**FIGURE 20 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 21 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



REFERENCE ONLY

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: J
Date: 05.12.08

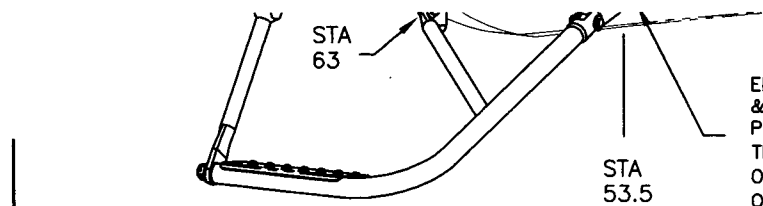
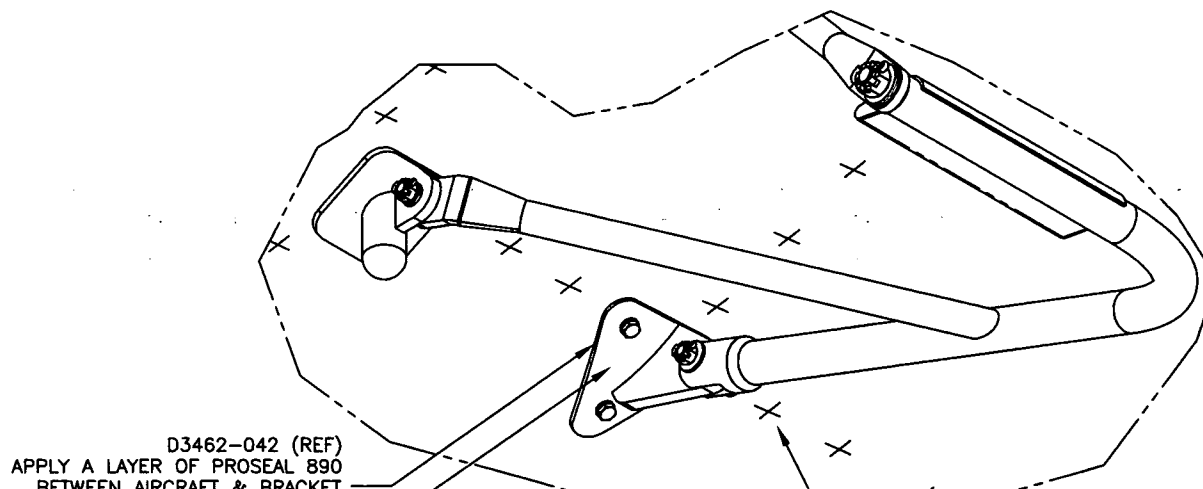


FIGURE 20

ENSURE THE STEP IS IN DOWN POSITION
& APPROXIMATELY PARALLEL TO GROUND.
PICKUP ON EXISTING RIVET HOLES.
TRANSFER HOLES TO D3462-042 (-032, SHOWN)
OR D3462-041 (-031, OPPOSITE).
OPEN HOLES TO $\varnothing 0.196$ (5 mm)

**FIGURE 19 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown)
D3462-041, (-031 Installation Opposite)**



REFERENCE ONLY